

**Work Order ID 60819**

Friday, July 23, 2010 10:27:00 AM



Page 1

Item ID: D350-748-201

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Installation, High Aft

Start Date: 7/23/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/16/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *RS*Date: *10-7-23*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-748-241	Rev E								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPPD350-748-201		CHG001						
110		0.00							
	BENDING MACHINE - CROSSTUBES								
CNC Bend 2	Memo	0.00							
CNC Alpha 160 Bender	Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT <u>D-350-748-201</u>								
120		0.00							
	QC15- Crosstube Dimensional Check								
QC	Memo	0.00							
Quality Control									

*10-7-23**SCBP**(IX)**MB 10-08-17**10-08-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

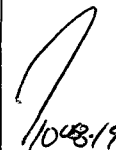
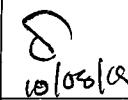
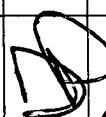
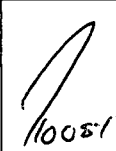
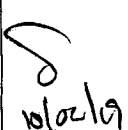
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Crosstubes	0.00							
	<b>Memo</b>	0.00							
	1-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs, Set-up drill table as per QSI 010								
	2-Deburr								
	3-Engrave Part # and Batch # as per Dwg D350-748-241								
	4-Remove all marks from tube within limits of D350-748-241								
	5- Apply a light coat of LPS3 on the interior of tube Batch: 108956								
140	QC6- Inspect dimensions to drawing	0.00							
	<b>Memo</b>	0.00							
	Quality Control								

MD 10-08-18

AWM 10-08-18

Pto →

⑩

W/O: 60819		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/6/19	# 110.5	ADD Step to Stress Relief (Steel) per AS7010 before step # 120				 1/04/19	 10/06/19	
10/8/19	# 110.5	Stress Relief per AS7010 temp <u>325°F</u> Start time <u>1130AM</u> End time <u>3:30PM</u>		10-8-19		 1/005/19	 10/02/19	

Part No: D350-748-201 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



4.2.3.12 Slide mandrel on top of both V-blocks and through bracket.

4.2.3.13 Tighten both nuts in an equal manner so that there is no play/movement in the mandrel.

4.2.3.14 Place buggy in proper orientation per bender folio.

#### **4.3 CROSSTUBE STRESS RELIEF ( STEEL)**

4.3.1 Stress relief shall be performed as soon as possible after bending:

4.3.1.1 Place Crosstubes in the oven vertically (as installed on the aircraft)

4.3.1.2 Heat crosstubes at 375 deg F for 4 hours

4.3.1.3 Allow to cool at room temperature

#### **4.4 DT8577A TABLE SETUP FOR ASSEMBLY**

4.4.1 Remove all bolts (2 per support) in both support stands.

4.4.2 Remove both support stands from previous location and place in proper hole location using the hole location chart for DT8577A.

4.4.3 Ensure cuff supports provide stability for crosstube during assembly in proper hole location.

4.4.4 Tighten all bolts (2 per support).

4.4.5 Make sure that painted supports are used for Support/Abrasion Strip installation.

4.4.6 Use proper support locating jigs for correct crosstubes. Check with blueprints for correct angles needed.

4.4.7 Use correct Abrasion strip locating tools for correct crosstubes.

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Cust Item ID:

Required Date: 8/16/2010 Req'd Qty: 1.00

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Outsource process-Cadplate per QSI017 4.1.9.1

0.00



Outsource3

Memo

0.00

Outsource process - Cad plate

Issue P/O: 12435  
Stress relief at 375° for 5 hours  
Magnetic Particle Inspect per ASTM E1444  
Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2  
Embrittle relief at 375° for 8 hours, Chromate Treat  
Possible Supplier: Southwest United Industries  
Ensure Certificate of Conformity is attached

CZ 10/8/19 ①

160

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

Pw/12 ②

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-201 PAR #: N/A Fault Category: Crosshatch NCR: Yes No DQA: h Date: 10.10.28  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: h Date: 10/10/28

NCR: 60819		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10 09 13	160	Scratches located on x tube R/H fwd side Scratches 2 0.002" deep	JP 10.09.13 Q51042	Buff out scratches cad plate touch up Issue P/O% <del>127</del> N/A	JP 10-09-13 <del>10-10-25</del>	10-09-13 Q51042	JP 10-09-13 Q51042	JP 10-09-13
	180	Pit marks found while grinding R.e. Process.	U 10-10-25	Scrap (Eng not adv)	JP 10-09-13	U 10-10-26	U 10-10-26	5 10/10/26

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  SprayPaint	SprayPaint	0.00							
	Memo	0.00							
Spray Painting	1-Prime inside crosstube as per QSI 005 4.2 2-Paint Outside of Tube as per Dart QSI 005 4.2								
190  QC	QC14- Inspect Spray Paint	0.00							
	Memo	0.00							
Quality Control	Then, Wrap in plastic bag to protect from scratches								
200  Crosstubes	Crosstubes	0.00							
	Memo	0.00							
Crosstubes	1-Install Ground wire Insert, then insert screw and washer 2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035. 3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS								



W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
220 	Pick Kit	0.00							
Packaging Packaging	Memo	0.00							
230 	QC4- 100% Inspect kits for completeness	0.00							
QC Quality Control	Memo	0.00							

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 8/16/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-748-201 Location: _____ PPP Rev: _____								
250		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

U 10/10/26

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Friday, July 23, 2010 10:27:05 AM

Page 1

Work Order ID: 60819

Parent Item: D350-748-201

Parent Item Name: Crosstube Installation, High Aft





Start Date: 7/23/2010

Required Date: 8/16/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A New Issue 06-07-05 JLM  
 IPP Rev: B Update qty of MS21042L5 06-09-12 KJ  
 IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD  
 IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC  
 IPP Rev: E 08.12.11 Step17 was step 21 KJ Verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-748-241TRN 		Manufactured	No	B59549		110	Each	0.0000	1				
Crosstube Turning Detail													
ALS4-1032-225 		Purchased	No			200	Each	6,043.000	1	1			
Insert													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				PK011				6043					
				110768				6043					
AN960JD10 	NAS1149D0363J	Purchased	No			200	Each	0.0000	1	1			
Washer													
D2856-400 		Manufactured	No			200	f	361.0188	1.181	1.243158			
Abraison Strip													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST403				361.0188421					
				56626				145.018842					
				59920				216					

1- cut as per dwg D2856

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 60819



Parent Item: D350-748-201



Parent Item Name: Crosstube Installation, High Aft

Start Date: 7/23/2010

Required Date: 8/16/2010

Start Qty: 1.00

Required Qty: 1.00

D3502-1

Manufactured No

200 Each

56.0000

2

2



Support



Location

Loc Qty

Loc Code

ST066

56

47120

1

50287

38

52903

17

MS21920-20

Purchased No

200 Each

103.0000

2

2



Clamp (per MIL-DTL-8783C)



Location

Loc Qty

Loc Code

LG

103

112624

18

114687

35

114779

24

115057

26

MS27039-1-10

Purchased No

200 Each

133.0000

1

1



Screw



Location

Loc Qty

Loc Code

ST291

133

112794

33

112940

100

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Required Date: 8/16/2010

Start Qty: 1.00

Required Qty: 1.00

AN4-41A

Purchased

No

220

Each

290.0000

8

8



Bolt

Location

Loc Qty

Loc Code

ST360

290

111424

4

113359

86

114941

100

115108

100

AN4-6A

Purchased

No

220

Each

1,243.000

16

16



Bolt

Location

Loc Qty

Loc Code

ST356

1243

112933

96

113149

344

114523

2

114615

1

114941

500

115108

300

AN5-32A

Purchased

No

220

Each

228.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST340

228

113121

4

114056

74

114405

50

115016

50

115108

50

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Start Qty: 1.00

Required Qty: 1.00

AN960JD416 NAS1149D0463J Purchased No

220

Each

0.0000

32

32



Washer

AN960JD516 NAS1149D0563J Purchased No

220

Each

0.0000

8

8



Washer

D3500-1 Manufactured No

220

Each

42.0000

4

4



Saddle

## Location

## Loc Qty

## Loc Code

ST424

26

59120

8

59422

18

ST425

16

55605

16

D3501-1 Manufactured No

220

Each

406.0000

16

16



Bushing

## Location

## Loc Qty

## Loc Code

ST066

406

45402

15

45918

112

48268

179

53779

100

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Required Date: 8/16/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

220

Each

3,897.000

24

24



Nut

Location

Loc Qty

Loc Code

ST300

3897

113422

68

114523

28

114718

23

114784

1778

115108

2000

MS21042L5

Purchased

No

220

Each

796.0000

4

4



Nut

Location

Loc Qty

Loc Code

ST139

296

114813

296

ST300

500

115156

500

W/O:		WORK ORDER CHANGES					
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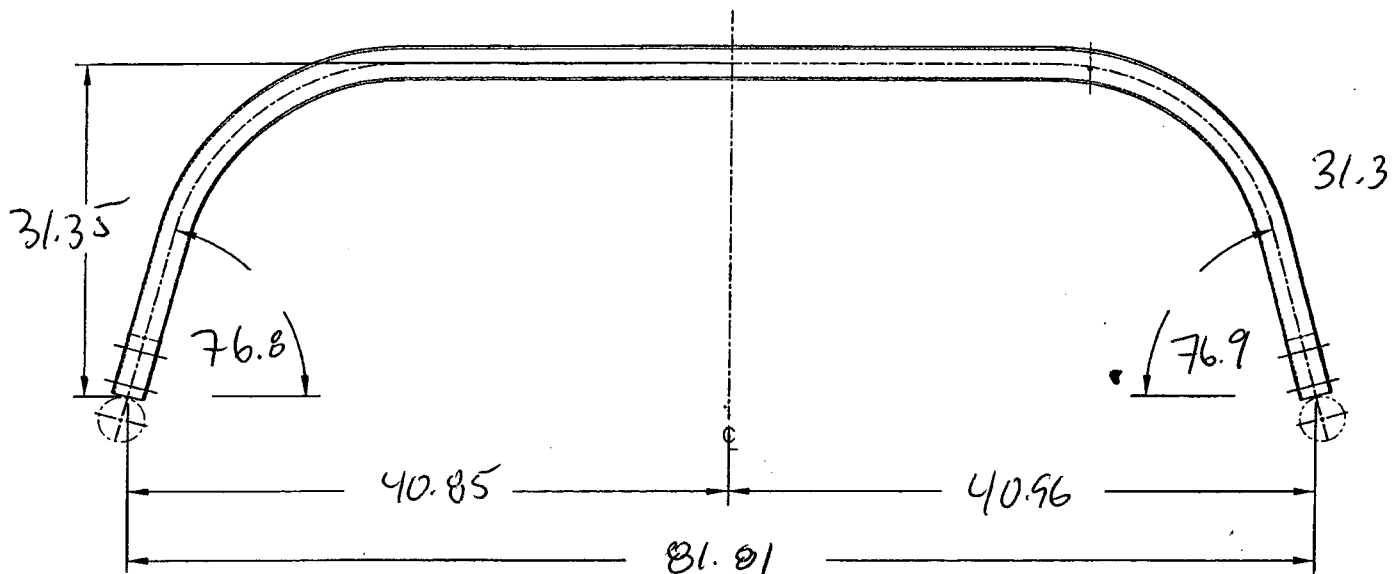
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	60819
Description: Crosstube High Aft (AS350/355)		Part Number:	D350-748-201
Inspection Dwg: D350-748-241		Rev: <del>B</del> E	Page 1 of 1

E 10.08.17

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments
0.05° twist @ 0.7° @ CFRP

QC15 Inspection	<i>[Signature]</i>
Date	10.08.18

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

Item	Qty -241	Part Number	Description
1	X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6018-125	CROSSTUBE
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AEIS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

#### GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6018-125  
FINISHED LENGTH = 122.700±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D350-748-241" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 29.85 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
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SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. *60819*

*PL 10-7-23*

**RELEASED**  
2009-10-29

E	REVISE GENERAL NOTES; UPDATE TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A8-3); ADD TOLERANCES (ZN C6-3, D2-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6018-125 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>qp</i>		
DRAWN	RF		
CHECKED	<i>qp</i>		
MFG. APPR.	<i>DS</i>		
APPROVED	<i>MP</i>		
DE APPR.	<i>MP</i>		
DATE	09.09.30		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D350-748-241	REV. E SHEET 1 OF 4
TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE NTS
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**Dart Aerospace Ltd**

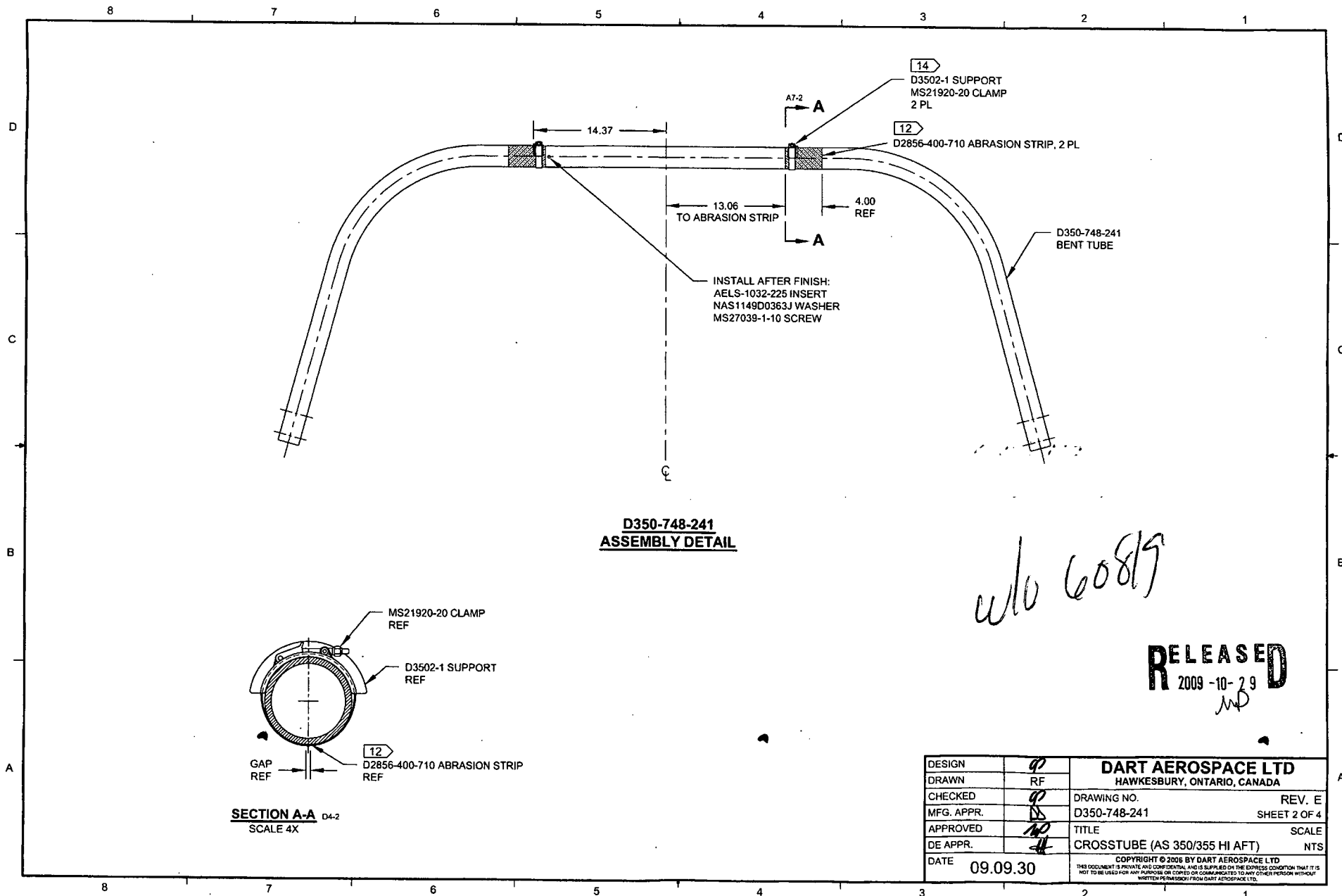
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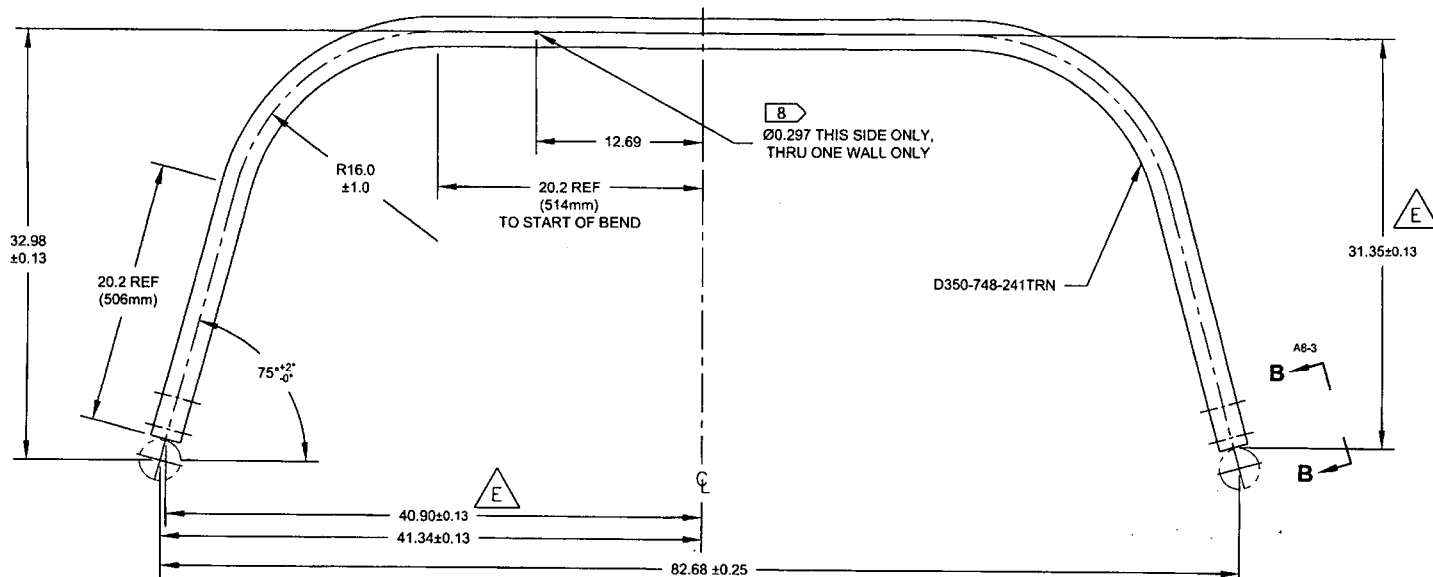
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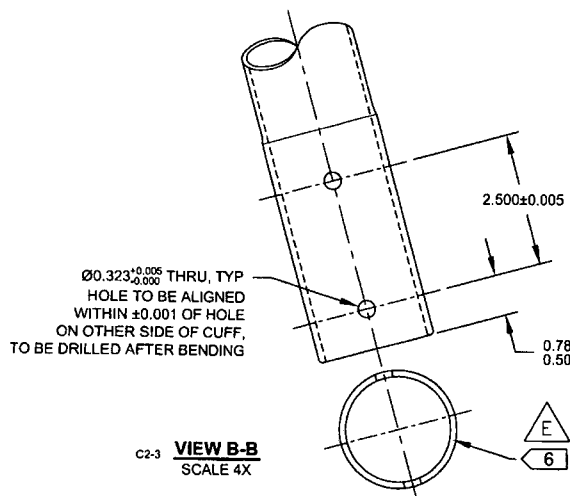
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**D350-748-241**  
**BENDING AND DRILLING DETAIL** 10

*w/o 60819*

**RELEASED**  
2009-10-29  
*MD*



DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D350-748-241	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	09.09.30	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

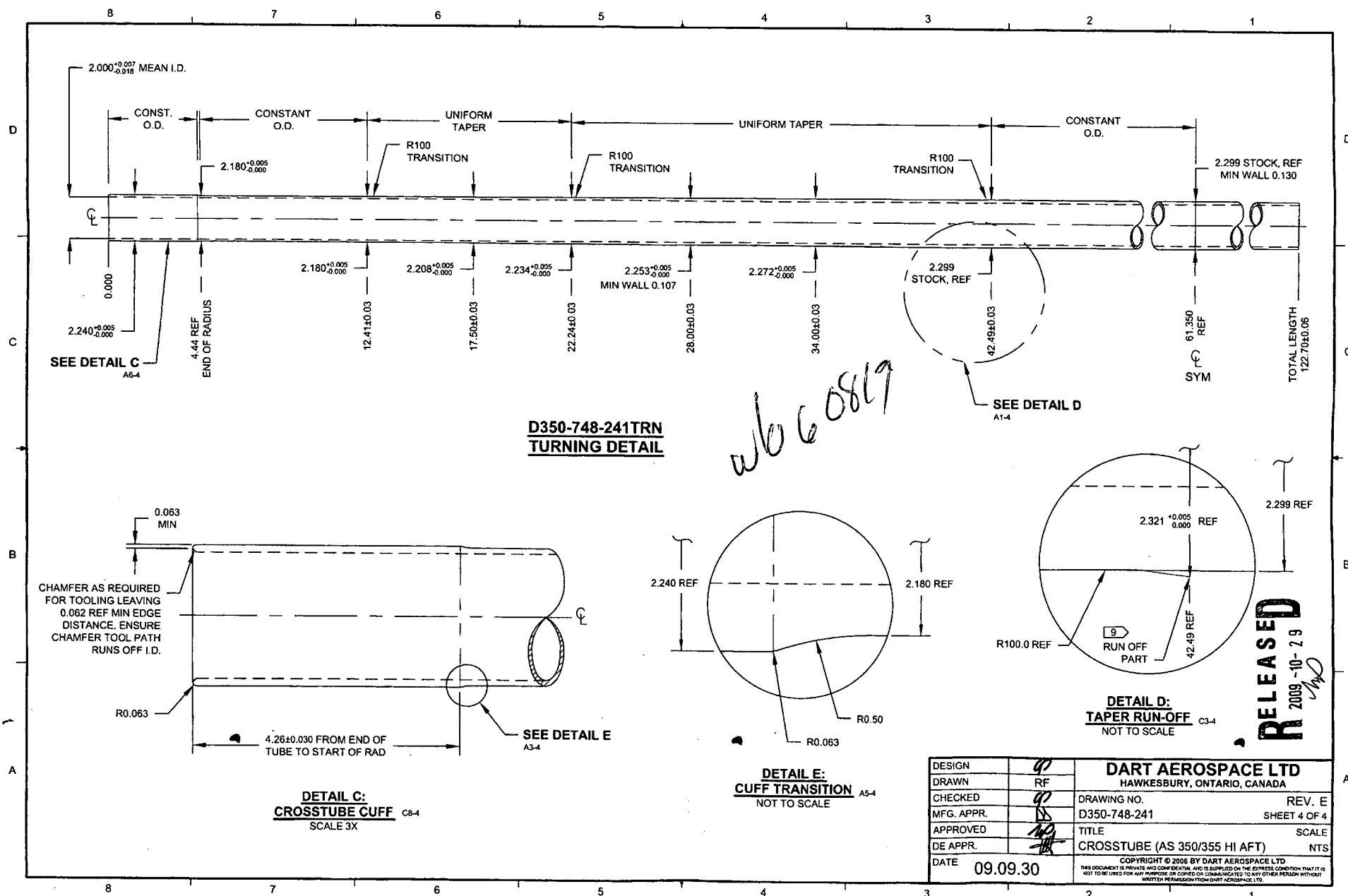
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**CERTIFICATE OF  
CONFORMANCE**

**CADORATH PLATING CO. LTD.  
2150 LOGAN AVENUE  
WINNIPEG, MANITOBA R2J-0J1**

**DATE: Sep-03-2010**

**CONSIGNED TO: Dart Aerospace Ltd.  
1270 Aberdeen St.  
Hawksbury, ON K6A 1K7**

**W/O #: 97982  
INVOICE #: 51085**

**CONTRACT OR  
PURCHASE ORDER # PO12435**

**DESCRIPTION: SKID**

**QTY 1**

**P/N # D350-748-201**

**S/N # B60819**

**STRESS REFLIF BAKE @ 375 DEG. BAKE HEAT CHART #10-907.  
MPI INSPECTED IAW ASTM-E-1444. CADMIUM PLATED IAW AMS-  
QQ-P-416C, TYPE 2 YELLOW, CLASS 1. BAKE HEAT CHART #10-923.**

**CERTIFICATE: I certify that the items indicated here on have  
been inspected and tested and conform to all specifications  
and requirements detailed on the contract or purchase order.**

**Approved Inspector:**



A large, stylized handwritten signature in black ink.